

Work Order ID 139991

December 16, 2015 11:53:41 AM

139991

Page 1

Item ID: E4733-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 12/16/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/1/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: SU Date: 20151217 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
E4733	<u>A</u>								

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 Mill Conv Memo 0.00
 Conventional Milling Machine 1-Machine WALL THICKNESS AND RADS per DWG
 DWG REV: A

2- deburr and break all sharp edges

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00
 Quality Control

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>6</u>			DAS 14 9-89 16/02/24
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>Can</u>	<u>of</u>	<u>all</u>	<u>16/02/24</u>
155 *155* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				<u>76</u>			DAS 38 9-89 FEB 25 2016

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>St</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

6 MLJ 16-02-25

MLJ FEB 26 2016

MLJ FEB 26 2016

Picklist Print

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Parent Item: E4733-5

F4733-5

Parent Item Name: Bracket

Start Date: 12/16/2015

Required Date: 3/1/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A.750W.125		Purchased			No		f	7.5000		2.105242			

M6061T6A 750W 125

angle .750 x .750 x .125w

**

Location

Loc Qty

Loc Code

MAT051

7.5

117481

7.5

M6061 T6 A 1.000 W 0.125

130524

2.104 J.C.-L. 16-02-23

8 7 6 5 4 3 2 1

D

C

B

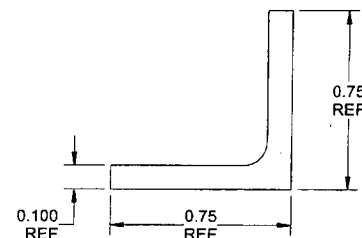
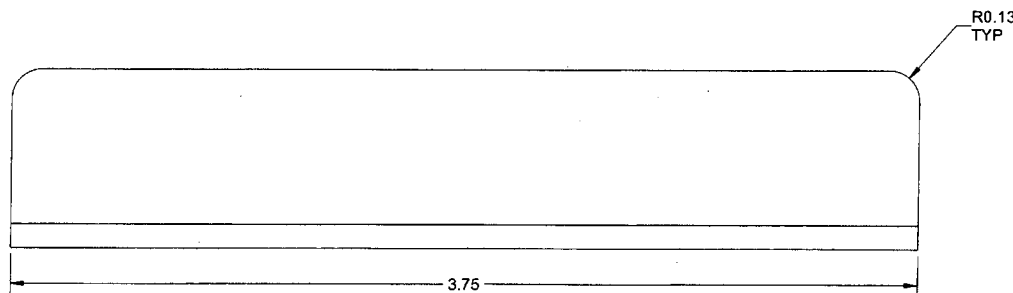
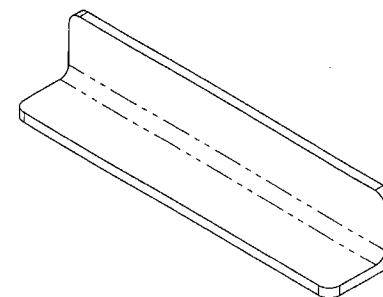
A

D

C

B

A



E4733-5 BRACKET

RELEASED
2013-11-28

20151212

SH 139991

- NOTES:**
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A750XW100
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.05 lbs

DESIGN		EAGLE COPTERS LTD	
DRAWN	SC	CALGARY, ALBERTA, CANADA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	E4733	SHEET 5 OF 6
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	BRACKET	NTS
DATE	12.12.12	COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.	

8 7 6 5 4 3 2 1

